

Split

Work Order ID 76203-1

76203

November-07-11 2:36:22 PM

Page 1

Item ID: D3179-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Litter Tie Down

3

Start Date: 07/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 21/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J.

Date: 11/11/08 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3179

Rev C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 12.150" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA297 Rev: 4A & Dwg D3179-1 Rev: C 2-
Deburr per dwg D3179-1

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Work Order ID 76203

76203

Page 2

November-07-11 2:36:22 PM

Item ID: D3179-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fwd Litter Tie Down

Stop

NS2

Start Date: 07/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 21/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

BA 11/12/19

4 0

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

4xpm-11/12/20

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

H 11/12-21

Work Order ID 76203

November-07-11 2:36:22 PM

76203

Page 3

Item ID: D3179-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fwd Litter Tie Down

Stop ***NS2***

Start Date: 07/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 21/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

4X M-11/12/21

14 11-12-21

EP 11/12/22 (3)

Work Order ID 76203

76203

Page 4

November-07-11 2:36:22 PM

Item ID: D3179-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fwd Litter Tie Down

Stop ***NS2***

Start Date: 07/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 21/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location **225**

0.00

200

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

(x3)

11/12/22 (3)

11/12/22

MF
11-12-22

Picklist Print

November-07-11 2:36:27 PM

Page 1

Work Order ID: 76203

76203

Parent Item: D3179-041

D3179-041

Parent Item Name: Fwd Litter Tie Down

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A1 03.01.09 Added Acid etch end alodine RF
IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP Rev:C 08-12-10 add part list DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

NAS1149D0332J

Purchased

No

100

Each

2,366.000

3

12

NAS1149D0332.J

Washer

**

PS 11/12/22

Location

Loc Qty

Loc Code

ST298

2366

105793

12

110985

4

117087

344

118078

6

118384

1000

119042

1000

9

D2372

Manufactured

No

180

Each

6.0000

2

8

D2372

Quick Release

**

PS 11/12/22

Location

Loc Qty

Loc Code

ST012

6

60716

6

D2444

Manufactured

No

180

Each

10.0000

1

4

D2444

Pip Pin Assembly

**

PS 11/12/22

Location

Loc Qty

Loc Code

ST

10

72147

10

3

Picklist Print

November-07-11 2:36:27 PM

Page 2

Work Order ID: 76203

76203

Parent Item: D3179-041

D3179-041

Parent Item Name: Fwd Litter Tie Down

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 4.00

Required Qty: 4.00

D6201	Manufactured	No	180	f	14.9400	1.0125	4.263158
-------	--------------	----	-----	---	---------	--------	----------

D6201

"T" Extrusion

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT004	14.94	
57767	1.34	
71208	13.6	

MS21042L3

Purchased No

180	Each	9,436.000	1	4
-----	------	-----------	---	---

MS21042L3

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	456	
117441	16	
117885	42	
118451	33	
118927	365	
ST516	6000	
119017	6000	
ST518	2980	
119075	2980	

MS27039-1-13

Purchased No

180	Each	32.0000	1	4
-----	------	---------	---	---

MS27039-1-13

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST291	32	
110844	32	

DART AEROSPACE LTD		Work Order:	76203
Description: Fwd Litter Tie Down Bracket		Part Number:	D3179-1
Inspection Dwg: D3179 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.005	✓		Dim. Catalogue	OK
Ø0.242	+0.005/-0.001	.241	✓			
R0.40	+/-0.030	.400	✓			
0.375	+/-0.010	.369	✓			
Ø0.191	+0.005/-0.001	.191	✓			
1.00	+/-0.030	1.006	✓			
1.70	+/-0.030	1.689	✓			
4.00	+/-0.030	3.990	✓			
1.50	+/-0.030	1.504	✓			
0.750	+/-0.010	.752	✓			
1.50	+/-0.030	1.504	✓			
10.500	+/-0.010	10.500	✓			
4.250	+/-0.010	4.250	✓			
0.750	+/-0.010	.752	✓			
1.000	+/-0.010	1.000	✓			
12.00	+/-0.030	12.005	✓			
1.00	+/-0.030	1.005	✓			
8.00	+/-0.030	8.000	✓			
Ø0.191	+0.005/-0.001	.191	✓			
R0.37	+/-0.030	.375	✓			
0.97	+/-0.030	.966	✓			
1.86	+/-0.030	1.857	✓			
1.750	+/-0.010					Not on drawing
0.375	+/-0.010	.374	✓			
2.875	+/-0.010	2.877	✓			
0.500	+/-0.010	.502	✓			
1.250	+/-0.010	1.248	✓			
1.625	+/-0.010	1.625	✓			
3.31	+/-0.030	3.311	✓			

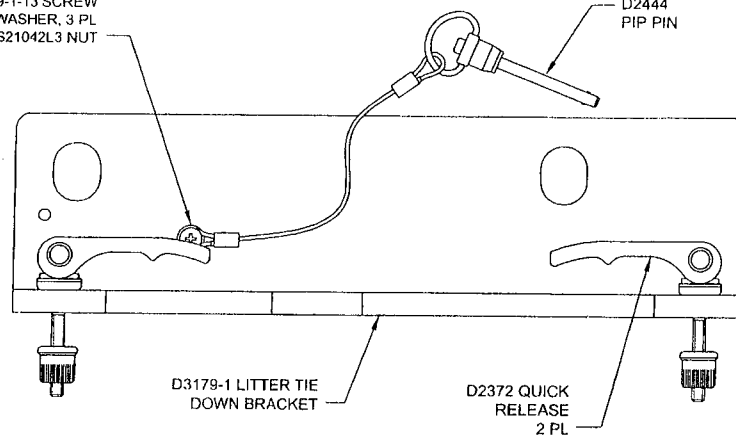
Measured by: BK/SA	Audited by: BA	Prototype Approval:	N/A
Date: 11/12/19	Date: 11/12/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue	P/O D3179-041	KJ/DD

Item	Qty	Part Number	Description
1	X	D3179-041	FWD LITTER TIE DOWN
2	2	D2372	QUICK RELEASE
3	1	D2444	PIP PIN
4	1	D3179-1	LITTER TIE DOWN BRACKET
5	1	MS21042L3	NUT
6	1	MS27039-1-13	SCREW
7	3	NAS1149D0332J	WASHER (OR AN960JD10L)

MS27039-1-13 SCREW
NAS1149D0332J WASHER, 3 PL
MS21042L3 NUT

D2444
PIP PIN



D3179-1 LITTER TIE
DOWN BRACKET

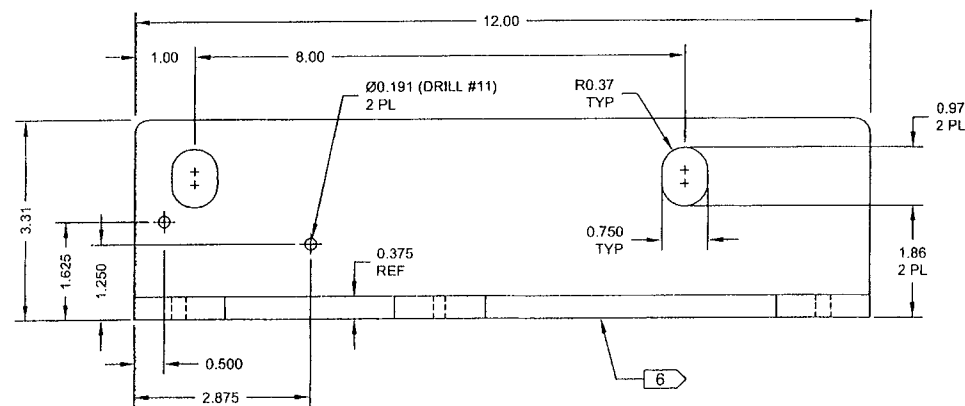
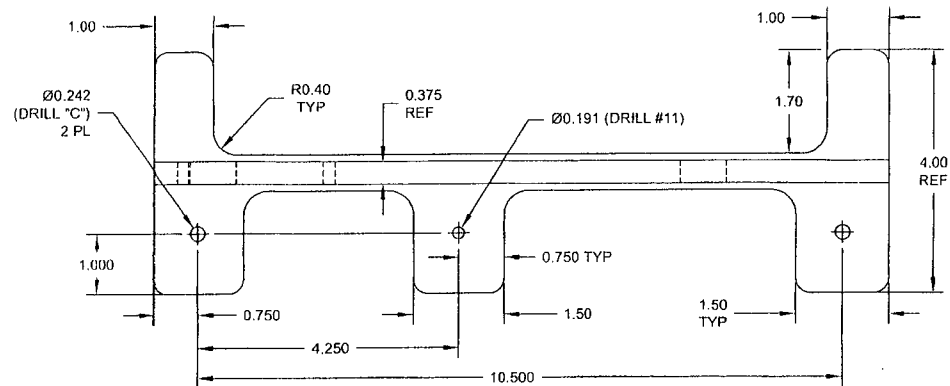
D2372 QUICK
RELEASE
2 PL

D3179-041 FWD LITTER TIE DOWN BRACKET

NOTES:
1) D3179-041 WEIGHT: 2.79 lbs

C	ADD D3179-041 & PART LIST (ZN B6-1, D2-1); D3179-1 WAS D3179 (ZN A5-2); REMOVE ENGRAVE P/N	RF	08.11.07
B	REFORMAT DRAWING; FINISH WAS ANODIZE	DC	07.06.06
A	NEW ISSUE	RF	02.12.09
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3179	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	LITTER TIE DOWN BRACKET	NTS
DATE	08.11.07	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS FOR YOUR USE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
08/11/21 M.B.



D3179-1 LITTER TIE DOWN BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T6511 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3179-1 USING FINE POINT PERMANENT INK MARKER ON THE BOTTOM FACE
- 7) WEIGHT: 2.3 lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3179	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LITTER TIE DOWN BRACKET	NTS
DATE	08.11.07	COPYRIGHT © 1995 BY DART AEROSPACE LTD	

RELEASED